

Work Order ID 78594

78594

Page 1

January-11-12 2:43:09 PM

Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 11/01/2012 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2438	Rev C

100	<u>PURCHASING</u>	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
<u>304 .063</u>	prog rev: <u>E</u>								
	dwg rev: <u>C</u>								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

\$ 12-1-23

(118)

12-1-23

cents
(418)

8.26124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: <u>456</u>								
Packaging	Memo	0.00							
Packaging									

118

So 12/01/25

12-01-25 118

12/1/25 118

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

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Item Name: Clamp

Start Date: 11/01/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/1/25 

MUF

12-01-25

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-11-12 2:43:13 PM

Page 1

Work Order ID: 78594

78594

Parent Item: D2438

D2438

Parent Item Name: Clamp

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	99.3300	0.04	4.210526			

M304S16GA

304/316 Sheet .063

**

1812-1-23

Location

Loc Qty

Loc Code

MAT020

99.33

119346

31.5

119653

67.83

119346

118

W/O:		WORK ORDER CHANGES					
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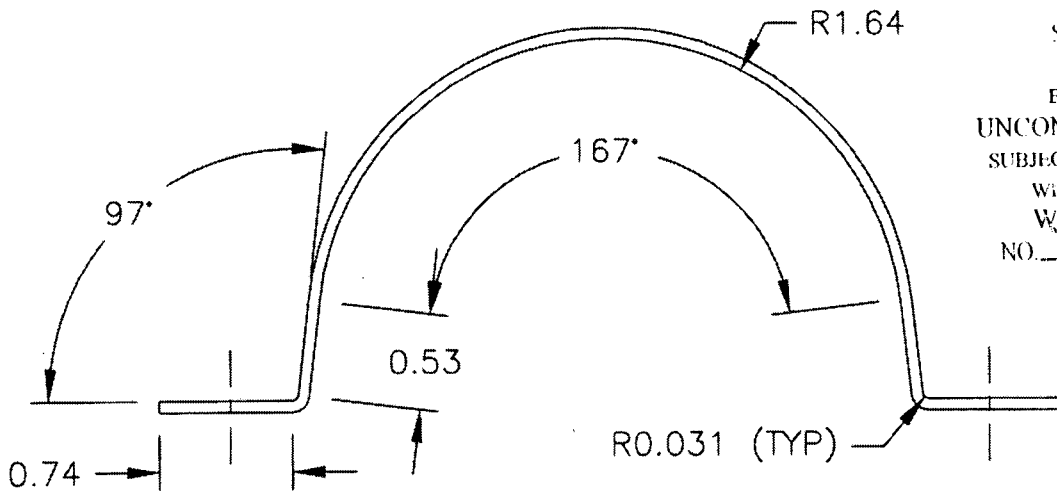
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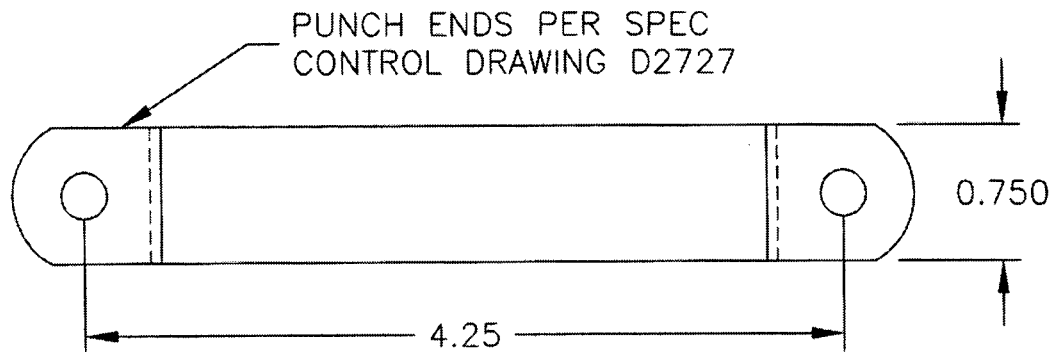


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78594
H.C.S.
12/01/11



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

W/O:		WORK ORDER CHANGES					
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